Work Orde August-24-12 1:	r ID 89325 09:03 PM			*8	9325	5*						Page 1	
Revision ID:	D350-636-105A Wedge Installation			Accept	*1	1900	040	100)* s	etup Sta	I M	S1*	
	8/17/12 Start	Qty: 1.00 l Qty: 1.00	*1* *1*			Cust Item I Customer:	D:				I XI		
Approvals:	Process Plan: A	ハレゴ	Date: 12/08 2	Z-Tooling: SPC (Y/N)): 		nte:		R	tun Sta Sto	P	R1* R2*	
Sequence ID/ Work Center II	Opera Descri			Set Up/ Run Ho		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr DSI 9456 100 *100* Document Control 110 *110* Packaging	Revision N A	Memo Photocopy CHG001	bluefile &type labels per	0.00 0.00 PPP D350-636-105 0.00	15 15 12 17 25 5A DSI9456					H461	MCT A	\\ \- \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	عاسله
Packaging Packaging 120 *120* QC Quality Control	QC4- 1	Memo 00% Inspect kits Memo	s for completeness	0.00	0A0 15 2 11 28				··· - -				·

											DQA:	Date:	
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											QA Closed:	Date:	
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	*
Part NCR	No.					Rework Scrap Use-as-is Work Order Update		•	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	=1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		:			Descri	ption of work order update	Ĭ.	Initial	Ad	ction	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
Landi	ina (· ·			General F	AUI	LT CATE	GORY				
Latio		Bending Centre No Cracks Crushed/ Cuffs		ntric to (o/s	Bend BOM/Route Broken/Damaged Burrs Contamination		- 1 `	ion Incomplete ions Incomplete,	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
		Heat Trea		Tube		Countersink Cut Too Short		Mislabe Misread			Positioned \		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Work Orde August-24-12 1:		9325		*893	325*							Page 2
Revision ID:	D350-636- Wedge Insta			Accept	*N900	040	100)*	Setup	Start Stop	171	S1* S2*
Item Name: Start Date: Required Date: Reference:	8/17/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:						.T/
Approvals:	Process F	Plan:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	1/1	R1* R2*
Sequence ID/ Work Center II 130 *130* Packaging)	Operation Description Memo		Set Up/ Run Hours 0.00 0.00 PPP D3550-636-105A/ D	Tool ID	Tool#	Plan Code	Accep Qty	t Re	eject	Reject Number	Insp. Stamp

140

QC21- Final Inspection - Work Order Release

0.00

*14**0***

QC Quality Control

Memo

0.00

12/11/29 Af WW 28

												DQA:	Date:	***
NCR:	Yes	/ No					WORK ORDER NON-O	COI	NFORM	ANCE / UP	DATE			
									,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,			QA Closed:	Date:	
Vork Ord	er:						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	:
Part						•	Rework Scrap Use-as-is		ľ	Skid-tube Machining Moforming	Crosstube Small Fab Finishing	-	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR	No.					•	Work Order Update]		Large Fab	Composite]	Supplier	
Root Cause		Date	Step	Qty	Des		ption of work order update	1	nitial ief Eng		tion ription	Sign & Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining														
паррточеи	1	<u> </u>	.	L	<u>L</u>			AUL	T CATE	GORY		1		L
Land	ing (Gear					General							
		Bending Centre No Cracks Crushed/C Cuffs Heat Trea Inspection Ripples in Torque W	Crimped it n Strip in Bend	Tube			Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/ nance led	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	\vdash	Turning S			11	\vdash	Drawing Finish	-	1	alibration equence		-		

Outside Dimensions

Wave/Twist in Tube

Picklist Print

August-24-12 1:09:02 PM

Work Order ID:

89325

Parent Item:

D350-636-105A

Parent Item Name:

Wedge Installation

Start Date: 8/17/12

Required Date: 9/21/12

Start Qty: 1.00

Required Qty: 1.00

Comments:	IPP RevA: New issu	ue DD verified by:I	EC										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3926-0 Wedge		Manufactured	No			110	Each	10.0000	2	2	133		
~ C				Location		Loc Oty	<u>La</u>	oc Code			•		
SW				ST203A		6							
				88	3178	. 6							
				ST205		4				/ /			\sim
				77	7145	4			<u>~ 7</u>	7145			
MS2104213 Nut		Purchased	No			110	Each	3,165.0000		13265		P	
				Location		Loc Qty	<u>L</u> c	oc Code					
Sm				316		795							
Sin				12	22452	795							
				ST300		680			** 4 - 41-21				
					17885	32							
					19017	510							
					19075	138							. A
				ST317		1690							
				12	22141	1690						•	
MS24693-S276 SGREW	·	Purchased	No			110	Each	105.0000	4	4	78		12/11/2
<i>C</i> -				Location		Loc Qty	L	oc Code			•		•
SW				ST288		105							
					04374	6					*		
					18612	99				8612			

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-C	100	VFORM	MANCE / UP	DATE	•		· ·
											QA Closed:	Date:	
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	•
Part I	_ No					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	1 '	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	ł				Descri	ption of work order update		nitial	Act	ion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data			·										
Equip/Tooling									:				
Operator	П												
Material													
Setup				:									
Other	П												
Process	П												
Supplier	П												
Training	П												
Unapproved													
						F/	AUL	T CATE	GORY				
Landi	ng Ge	ear				General						-	
	E	Bending				Bend		Grain			Ovalized		Pressure/Forced
	\Box c	entre No	t Concer	tric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	\Box	crushed/0	rimped.			Burrs		Instruct	ions Incomplete/U	Jnclear	Part Lost/Mi	issing	Wrong Stock Pulled
!	\Box	Cuffs				Contamination		Mainte	enance		Part Moved		-
	□	leat Trea	t			Countersink		Mislabe	led		Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

August-24-12 1:09:02 PM

Work Order ID:

89325

Parent Item:

D350-636-105A

Parent Item Name:

Wedge Installation

Start Date: 8/17/12 Start Qty: 100

Required Date: 9/21/12

Required Qty: 1.00

NAS11491	D0363J
Washer	

Purchased

No

110

Each

4,924.0000

Location	Loc Qty	Loc Code	
ST297	4574		
122378	4574		122378
ST298	350		
116025	1		
117601	61		
119537	33		
120142	13		
120308	17		
121243	121		
121524	104		

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	100	NFORM	MANCE / UP	DATE			
											QA Closed:	Date:	
Work Ord	er.					DISPOSITION	·			AGAINST DE	PARTMENT	/PROCESS	ą
Part I						Rework Scrap		r	Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality Other
NCR I	No.	-				Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/sto	re/Packaging Supplier	Other
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator	Ш												
Material								;					
Setup	Ш												
Other													
Process								•					
Supplier													•
Training													
Unapproved													
						F	AUL	T CATE	GORY				
Landi	ng (ear				General		_			_		_
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to (o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped.		Γ	Burrs		Instruct	ions Incomplete	'Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		-
		Heat Trea	t			Countersink		Mislabe	led		Positioned \	Vrong	
		Inspection	n Strip in	Tube		Cut Too Short		Misread	I		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

DART SERVICE INSTRUCTION TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV. F OR EARLIER

REF. FAA STC: SR00646SE REF. TCCA STC: SH99-7 REF. CAA AIRWORTHINESS APROVAL NOTE: 28081, 28082

The D350-636-105A/B Wedge Kits can be installed on D350-636-011/-012/-013/-014 Skidtube installations to help prevent the D2741 blade from getting snagged on objects on the ground during take-off. The D350-636-105A Wedge Kit is compatible with Apical Float Systems per STC SR00470LA, SR00645LA and SR00831LA with the low angle float extensions but is not compatible with OEM skidtubes. The D350-636-105B Wedge Kit is compatible with non-float tube equipped skidtubes but is not compatible with OEM skidtubes.

The D350-636-105A/B Wedge kits are installed as follows:

- 1) Remove the D2741 blades from the D350-636 skidtube assemblies
- 2) Drill 2x Ø0.201 (#7 drill) per D2741 blade as shown in Figure 1 Sheet 2 and deburr
- 3) Countersink the 2 holes \emptyset 0.385 x 100° from the bottom of each D2741 blade
- 4) Position the D3926-1/-3 wedge on the top side of each D2741 blade centered between the left and right sides
- 5) Transfer drill 2x \emptyset 0.201 (#7 drill) from each D2741 blade to the D3926-1/-3 wedge and deburn
- 6) Touch up holes in D2741 blade with primer per Aircraft Maintenance Manual
- 7) Install the D3926-1 wedge on each D2741 blade using the hardware shown in Figure 2 Sheet 2
- 8) Install the D3926-3 wedge on each D2741 blade using the hardware shown in Figure 3 Sheet 3
- 9) Re-install the D2741 blade onto the D350-636 skidtube assembly in accordance with IIN-D350-636.
- 10) It is acceptable to install blade tape (abrasion strip material) on the float tube extension to prevent wear between the D3926-1 wedge and the float tube extension.

WEIGHT AND BALANCE

Installation	Weight	La	teral	Longitudinal			
mound(on		Arm	Moment	Arm	Moment		
D350-636-105A	0.50 lb	0.0 in	0.0 in-lb	178.25 in	89.13 in-lb		
Wedge Kit	0.23 kg	0.0 m	0.0 m-kg	4.53 m	1.04 m-kg		
D350-636-105B	0.50 lb	0.0 in	0.0 in-lb	178.25 in	89.13 in-lb		
Wedge Kit	0.23 kg	0.0 m	0.0 m-kg	4.53 m	1.04 m-kg		

PARTS LIST

QTY. -105A	QTY. -105B	PART NUMBER	DESCRIPTION
X		D350-636-105A	Wedge Kit
	Х	D350-636-105B	Wedge Kit
2		D3926-1	WEDGE
	2	D3926-3	WEDGE
4	4	MS21042L3	NUT
4	4	MS24693S276	SCREW
4	4	NAS1149D0363J	WASHER

UNCONTROLLED (COM SUBJECT TO AMENDMENT WITHOUT NOTICE ENGINEERING

	r				·					
Α	NEWIS	SUE		%	09.07.23					
REV.			DESCRIPTION	BY	BY DATE					
DESIGN	1	3 5	DART AFRO	SPACE IISA	INC					
DRAWN	J	3 5	DART AEROSPACE USA, INC. PORT HADLOCK, WA							
CHECK	ED	ASS	DRAWING NO.		REV. A					
MFG. A	PPR.	N/A	DSI 9456		SHEET 1 OF 3					
APPRO	VED	1494	TITLE		SCALE					
DE APP	R.		WEDGE KIT		NTS					
DATE	09.0	7.23	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.							

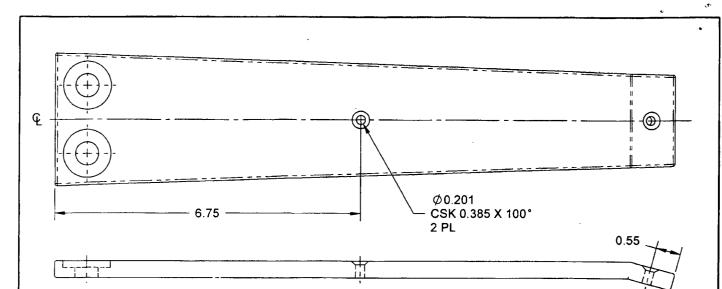


FIGURE 1: D2741 BLADE DRILLING DETAIL

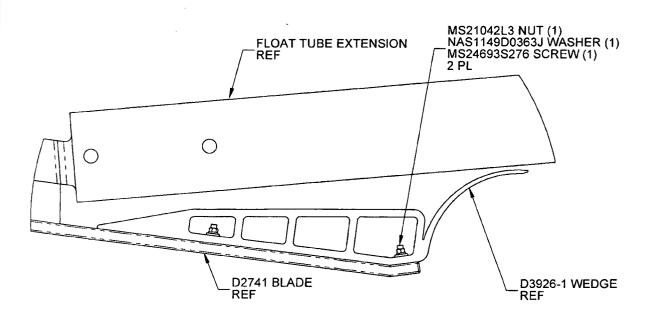


FIGURE 2: D3926-1 WEDGE INSTALLATION

DESIGN	3 5.	DART AEROSPACE USA, INC.			
DRAWN	3 5	PORT HADLOCK, WA			
CHECKED	A35	DRAWING NO.	REV. A		
MFG. APPR.	N/A	DSI 9456	SHEET 2 OF 3		
APPROVED	140,1	TITLE	SCALE		
DE APPR.	-#	WEDGE KIT	NTS		
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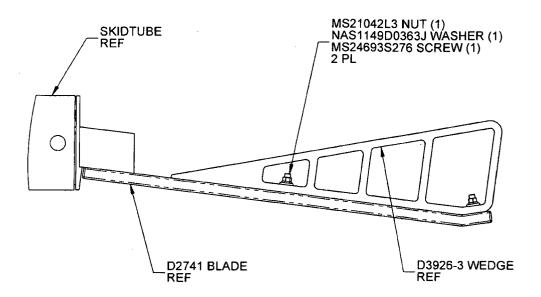


FIGURE 3: D3926-3 WEDGE INSTALLATION

DESIGN	35	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	3 5.			
CHECKED	455	DRAWING NO.	REV. A	
MFG. APPR.	N/A	DSI 9456	SHEET 3 OF 3	
APPROVED	140	TITLE	SCALE	
DE APPR.	4	WEDGE KIT	NTS	
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IIN-D350-636 Page 28 of 31

7.0 PARTS LIST (D350-636-101/-103/-104/-105A/-105B/-107/-107A/-107B/-109 KITS)

Item	Qty -101	Qty -103	Qty -104	Qty -105A .	Qty\ 105B	Qty -107	Qty -107A	Qty -107B	Qty -109	Part Number	Description
	X				ľ l					D350-636-101	TOE STEP KIT (LH/RH)
		X								D350-636-103	APICAL FLOAT CONVERSION KIT, LH
			Х							D350-636-104	APICAL FLOAT CONVERSION KIT, RH
				X						D350-636-105A	WEDGE KIT
					X					D350-636-105B	WEDGE KIT
	-					X				D350-636-107	CABLE GUARD KIT
						1	X			D350-636-107A	FWD CABLE GUARD
						1		X		D350-636-107B	AFT CABLE GUARD
									Х	D350-636-109	TOW RING KIT
8		1		—						D3488-041	BLADE FITTING, LH (REPLACES D2742-1)
8			1	<u> </u>						D3488-042	BLADE FITTING, RH (REPLACES D2742-2)
10		2	2							AN8C21A	BOLT (REPLACES AN8-16A)
11		2	2							AN960JD816	WASHER (OR NAS1149DO863J)
12		2	2							MS21083C8	NUT (REPLACES MS21083N8)
12		-									
26B		4	4					,		AN3C7A	BOLT (REPLACES AN3-7A)
27		4	4							AN960C10L	WASHER (REPLACES AN960JD10)
		7									
40	1									D3487-1	TOE STEP ASSEMBLY
43		2	2							D3493-1	WASHER
50		2	2							D3532-1	WASHER
30					-						
60				\2 22			,		-	D3926-1	-WEDGE
61					2					D3926-3	WEDGE
62				-4-	4					-MS21042L3*	NUT
63				c4 ⊃	4					MS24693S276	SCREW
64				C4-7	4					NAS1149D0363J-	<u> </u>
04				-37						1010-11-10-00-00	777.10(1)
70							1			D3927-1	FWD CABLE GUARD
70							-	1		D3927-3	AFT CABLE GUARD
72				 	 		2	-		D3928-1	BRACKET
73					 		.2	_		AN4-14A	BOLT
74								1		BLBS-020	PIP PIN
75					\vdash		2	<u> </u>		MS21042L4	NUT
76				l	 		4			NAS1149D0463J	WASHER
- /0				 	 		7			14.0117007000	777,01,121
				\vdash					1	D3407-043	TOW RING ASSEMBLY
80									2	D3417-9	WASHER
81									1	D3417-9 D3456-1	WASHER
82 83					 	·		_	1	MS21043-4	NUT

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Revision: I

Date: 10.10.25